DEPARTMENT OF TRANSPORTATION
DIVISION OF ENGINEERING SERVICES
Office of Structural Materials
Quality Assurance and Source Inspection

Bay Area Branch
690 Walnut Ave.St. 150
Vallejo, CA 94592-1133
(707) 649-5453
(707) 649-5493

Contract #: 04-0120F4
Cty: SF/ALA Rte: 80 PM: 13.2/13.9
File #: 1.28

WELDING INSPECTION REPORT

Resident Engineer: Casey, William
Address: 333 Burma Road
City: Oakland, CA 94607

Report No: WIR-028169
Date Inspected: 12-Aug-2012

Project Name: SAS Superstructure
Prime Contractor: American Bridge/Fluor Enterprises, a JV
Contractor: American Bridge/Fluor Enterprises, a JV

OSM Arrival Time: 700
OSM Departure Time: 1530
Location: Job site

CWI Name: Salvador Merino

Inspected CWI report:	☐ Yes	☑ No	☐ N/A	**CWI Present:**	☑ Yes	☐ No	
Electrode to specification:	☑ Yes	☐ No	☐ N/A	**Rod Oven in Use:**	☑ Yes	☐ No	☐ N/A
Qualified Welders:	☑ Yes	☐ No	☐ N/A	**Weld Procedures Followed:**	☑ Yes	☐ No	☐ N/A
Approved Drawings:	☑ Yes	☐ No	☐ N/A	**Verified Joint Fit-up:**	☐ Yes	☑ No	☐ N/A
				Approved WPS:	☑ Yes	☐ No	☐ N/A
				Delayed / Cancelled:	☐ Yes	☑ No	☐ N/A

Bridge No: 34-0006
Component: OBG

Summary of Items Observed:

Quality Assurance Inspector (QAI) Rodney Patterson was at the American Bridge/Fluor (ABF) job site at Yerba Buena Island in California between the times noted above in order to monitor Quality Control functions and the in process work being performed by ABF personnel. The following items were observed:

The QAI observed ABF/JV qualified welder Wai Kitlai #2953 performing Carbon Arc Gouging (CAG) for the repair of the deck panel drop-in splice designated as 13E-E2.8. The ABF/JV QC inspector Salvador Merino was observed performing magnetic particle testing (MT) in way of the repair excavation at Y=9990 first time repair,

The ABF qualified welder was observed later in the shift performing Shielded Metal Arc Welding (SMAW) of the repair area in the 4G position utilizing the Caltrans approved Welding Procedure Specifications ABF-WPS-D1. 5-1004-Repair. The weld and surrounding area was brought to temperature by the use of inductions heaters and maintained throughout welding. Due to the first time repair at these locations approval for repair (RWR) of this weld was not required.

The QAI noted and periodically observed ABF/JV qualified welder Jia Yan #1571 performing Carbon Arc Gouging (CAG) in order to remove the backing bar from face B of the edge plate splice at panel point 121.6 for the weld designated as 13E-PP121.6-G. The ABF/JV QC inspector Salvador Merino was then observed performing magnetic particle testing (MT) of the backgouged root after the groove was ground to bright metal. No indications were observed by QC at the time of inspection.

Welder Jia Yan #1571 was then observed welding the backgouged portion of the edge plate splice by the use of

Shielded Metal Arc Welding (SMAW) in the 3G position utilizing the Caltrans approved Welding Procedure Specification ABF-WPS-D1.5-1040-C. The weld surface and surrounding area was brought to temperature by the use of a gas torch and was confirmed by QC inspector Salvador Merino prior to welding.

During the Quality Assurance (QA) random in-process visual inspection of the welding operations on the OBG East End, the QA inspector observed ABF personnel welding the edge plate field splice between lift 13E and 14E (EP3018 to EP3028) with planar misalignment measuring from 3mm~14mm. The edge plate thickness at this connection is 20mm and the weld is designated as 13E/14E-G. The QA task leader was notified in writing of the non-compliant issue for further discussion with the Caltrans Structural Materials Representative (SMR) and ABF Management.

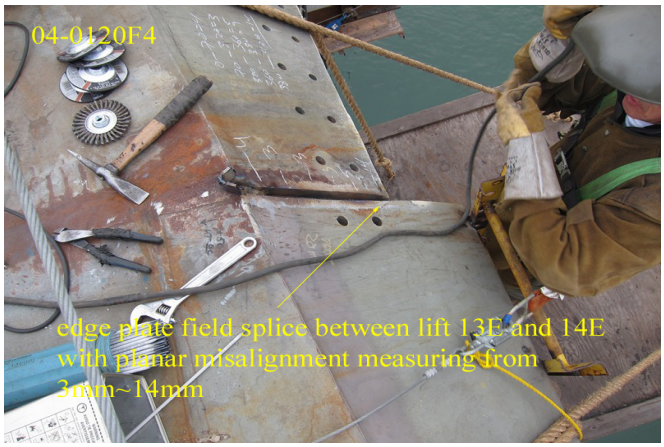
The QA inspector observed at random intervals, ABF/JV qualified welder Chris Bowles #9317 Shielded Metal Arc Welding (SMAW) in the 2G/3G position utilizing the Caltrans approved Welding Procedure Specification ABF-WPS-D1.5-1040A for the welding in the 3G position and ABF-WPS-D1.5-1050A for the 2G position. The welding observed was for the floor beam web splice at panel point 120 and is designated as 13E-PP120-E2. 0-FBW1 and 13E-PP120-E2.0-FBW2. The weld surface and surrounding area was brought to temperature by the use of a gas torch. The ABF QC inspector Fred Michaels was observed monitoring the welding parameters at the beginning of the shift.

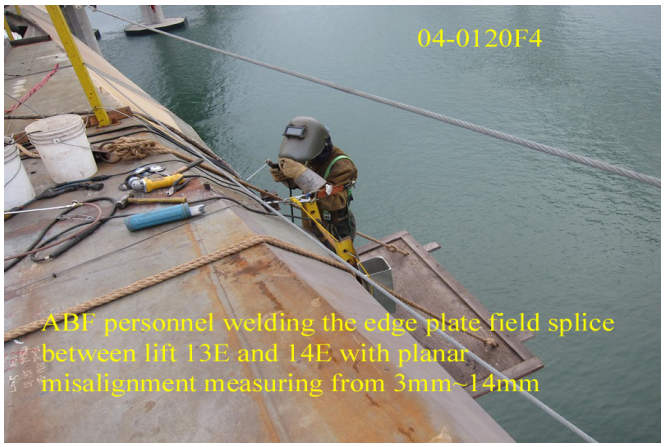
The QAI spent a portion of this shift reviewing and documenting the status and completion of various production welding tracking logs for lift 13W/14W and 13E-14E drop-in deck work currently in-process. The QA recorded the information on the OBG tracking log.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

Summary of Conversations:

As noted above





Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Nina Choy 510-385-5910, who represents the Office of Structural Materials for your project.

WELDING INSPECTION REPORT

(Continued Page 3 of 3)

Inspected By:	Patterson,Rodney	Quality Assurance Inspector
Reviewed By:	Levell,Bill	QA Reviewer